



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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D5571-1
Job Sheet 196928



Part No: D5571-1

Job Qty: 2 pcs

Part Name: Saddle



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/25/19

Job Tracking No:

Due Date: 7/10/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG D5571 REV.B IPP REV:A 18.06.12 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Machining - Issue SN	2 pcs		7/10/19	0.00	0.00	HAAS - 5		<i>19-07-10</i>
110	HAAS 5 Axis	2 pcs		7/10/19	0.50	5.49	HAAS - 5		<i>19-07-12</i>
120	QC 2	2 pcs		7/10/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		<i>19-07-12</i>
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		



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Container No: S197047



Part: D5571-1

Job No: 196928

Serial No/Batch: S197047

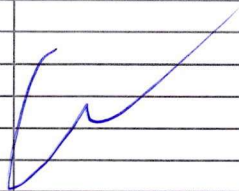
Revision: B

Inspector:

Exp Date:

Instructions:

Date: 07/10/19

130 QC 8	2 pcs	7/10/19	0.00 0.00	QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	m/19/07/12
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
140 Handfinish - 1-1 Chemical-B4B	2 pcs	7/10/19	0.00 0.25	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 -	

				B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 QC 7	2 pcs	7/10/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	DAS
				QC 7 - 60	19
				QC 7 - 9	9-09
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
152 Spray Paint - 2 - B4B	2 pcs	7/10/19	0.00 1.00	Spray Paint - 1 - B4B	RD 19-7-12
				Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
154 QC 14	2 pcs	7/10/19	0.00 0.00	QC 14 - 15	
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	DAS
				QC 14 - 58	19
				QC 14 - 59	9-09
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
				QC 14 - 61	
				QC 14 - 81	
160 Packaging 3-1 - Stock - B4B	2 pcs	7/10/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	DAS
				Packaging 3 - 3 - B4B	19
				Packaging 3 - 4 - B4B	9-09
				Packaging 3 - 5 - B4B	

				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170 QC 21 - SA	2 pcs	7/10/19	0.00 0.00	QC 21 - SA - 21	6102 51 700 DAS 70
				QC 21 - SA - 70	
				QC 21 - SA - 53	9-89
Part Op 110 - (HAAS CNC vertical machine #5), 1-Machine per folio FC101 DWG REV: <u>B</u> FOLIO REV: <u>AA</u> 2- Descriptions: Deburr and break all sharp edges 120 - (QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check) 140 - (Chemical Conversion Coat per QSI005 4.1) 150 - (QC7-Inspect Chemical Conversion Coat) 152 - PRIME ONLY IN AREA SHOWN (SADDLE-TO-SKIDTUBE BORE AND EDGE ALL AROUND) PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER BATCH: <u>3189539</u>) 154 - (QC14- Inspect Spray Paint) 160 - (Identify as per dwg & Stock Location: _____) 170 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M7050T7451P4.50X6.25X10.50	7050 Aluminum Plate, 4.5" Thick x 6.25" Wide x 10.50" Long	2 Ea (1 ea)	100-Machining - Issue SN	<u>S061608</u>	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Machining - Issue SN	M7050T7451P4.50X6.25X10.50	2	2	0	
Part Specifications					
Specifications could not be found.					

DART AEROSPACE LTD		Work Order: 196928
Description: Saddle		Part Number: DSS71-1
Inspection Dwg: DSS71 Rev: 45 B		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.018	+/- .010	2.023	✓		Height gauge	
1.461	+/- .010	1.460	✓		SLIO	vern
.763	+/- .005	.763	✓			
.273	+/- .010	.273	✓			
Ø.098	+0.004/-0.001	.101	✓			
.280	+/- .010	.278	✓			
.559	+/- .010	.558	✓			
1.968	+/- .010	1.968	✓			
1.421	+/- .010	1.421	✓			
.547	+/- .010	.547	✓			
.654	+/- .010	.654	✓			
.315	+/- .010	.313	✓			
.629	+/- .010	.628	✓			
6.115	+/- .010	6.117	✓			
1.767	+/- .010	1.765	✓			
1.28	+/- .030	1.280	✓			
.467	+/- .010	.465	✓			
.485	+/- .010	.483	✓			
.992	+/- .005	.992	✓			
.992	+/- .005	.992	✓			
5.128	+/- .010	5.126	✓		Height gauge	
10.256	+/- .010	10.257	✓		"	
Ø.193	+0.005/-0.001	.194	✓		SLIO	vern
.284	+/- .010	.284	✓			
.284	+/- .010	.284	✓			
.614	+/- .010	.612	✓			
2.407	+/- .010	2.412	✓			
.376	+/- .010	.376	✓			
1.181	+/- .010	1.184	✓			
.583	+/- .010	.581	✓			
Ø.386	+0.006/-0.001	.387	✓			
.602	+/- .010	.600	✓			

Measured by: DAS	Checked by: <i>Smk</i>	QC Inspector:
Date: 19-07-11	Date: 19/07/12	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

DART AEROSPACE LTD		Work Order: 196928
Description: Saddle		Part Number: DSS71-1
Inspection Dwg: DSS71 Rev: A B		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.91	+/- .030	.910	✓		SLIO	✓
1.189	+/- .010	1.189	✓			
Ø 3.580	+/- .005	3.578	✓			
3.720	+/- .010	3.721	✓			
.156	+/- .010	.156	✓			
Ø 2.795	+/- .010	2.795	✓			
Ø .189	+ .005/- .001	.190	✓			
2.952	+/- .010	2.955	✓			
.794	+/- .010	.794	✓			
1.004	+/- .005	1.004	✓			
3.425	+/- .005	3.428	✓			
Ø .193	+ .005/- .001	.194	✓			
4.035	+/- .010	4.035	✓			
.339	+/- .010	.339	✓			
1.338	+/- .010	1.334	✓			
3.358	+/- .010	3.359	✓			
.467	+/- .010	.465	✓			
.08	+/- .030	.084	✓			
3.866	+/- .010	3.865	✓			
Ø 3.559	+ .010/- .000	3.565	✓			
R.08	+/- .030	.090	✓			
4.035	+/- .010	4.035	✓			
.973	+/- .010	.973	✓			
Ø .397	+ .006/- .001	.399	✓			
1.339	+/- .010	1.339	✓			
.807	+/- .010	.806	✓			
.493	+/- .010	.491	✓			
Ø .193	+ .005/- .001	.193	✓			
1.58	+/- .030	1.580	✓			
.973	+/- .010	.973	✓			
.375	+/- .010	.380	✓			
.375	+/- .010	.350	✓			

Measured by: 20 099	Checked by: [Signature]	QC Inspector:
Date: 19-07-11	Date: 19/07/12	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

INSPECTION SHEET

DAS20
9-89

(If necessary)

B